

Date: Tuesday, 29/04/2008 9:22:49 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 38867	
Estimate Number : 12734	
P.O. Number :	Part Number : D353525
This Issue : 29/04/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 38162	Material :
Written By :	Due Date : 08/05/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 08.4.29</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.5355 sf(s)/Unit Total: 10.7100 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 107744 B 8-5-1

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

B 8-5-1

(21)

2-Debur if necessary B 8-5-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/05/07 (420)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SB 08/05/15

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 29/04/2008 9:22:49 AM
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Process Sheet

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Drawing Name: WEARSHOE

Job Number: 38867

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/16 (21)

7.0

POWDER COATING

POWDER COATING



M105692



(21X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:30

OVEN TEMPERATURE:

320 °F

FINISH TIME:

3:00 PM

M-J 08/05/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-20

(X21)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

JS

08-05-20

(X21)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38867
Description: Wearshoe		Part Number: D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.887	X			
1.937	+/-0.010	1.936	X			
1.450	+/-0.010	1.450	X			
5.450	+/-0.010	5.453	X			
10.900	+/-0.010	10.900	X			
16.350	+/-0.010	16.350	X			
21.800	+/-0.010	21.800	X			
Ø0.188	+0.005/-0.001	.191	X			
12.750	+/-0.010	12.750	X			
6.75	+/-0.030	6.755	X			
6.00	+/-0.030	6.00	X			
0.300	+/-0.010	0.303	X			
0.300	+/-0.010	0.305	X			
0.038	+/-0.010	0.037	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 8-5-1	Date: 08/05/01	Date:	N/A

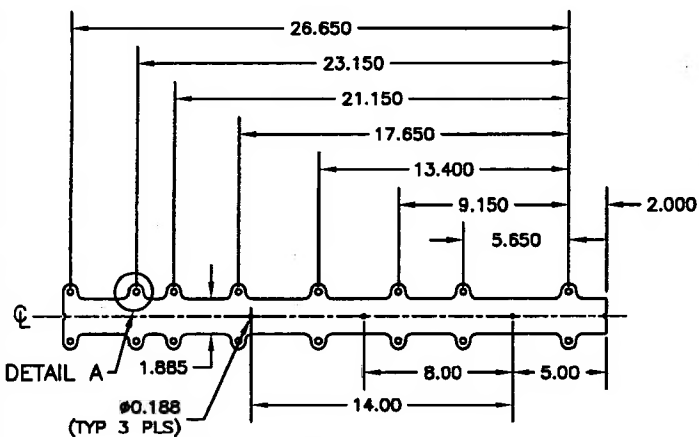
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART

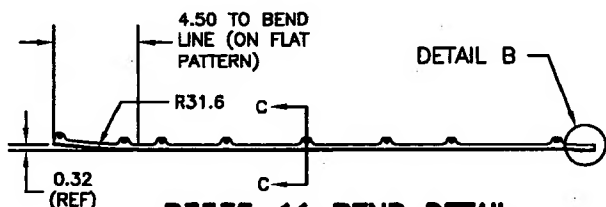
RELEASED

07.04.24

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C.B.	M.	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

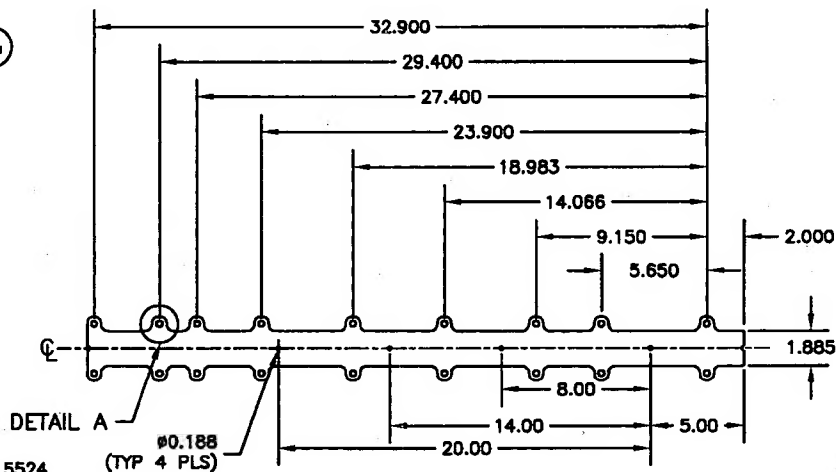


D3535-11F FLAT PATTERN

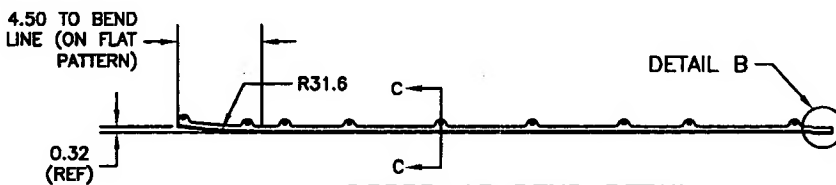


D3535-11 BEND DETAIL

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NO. 38867



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

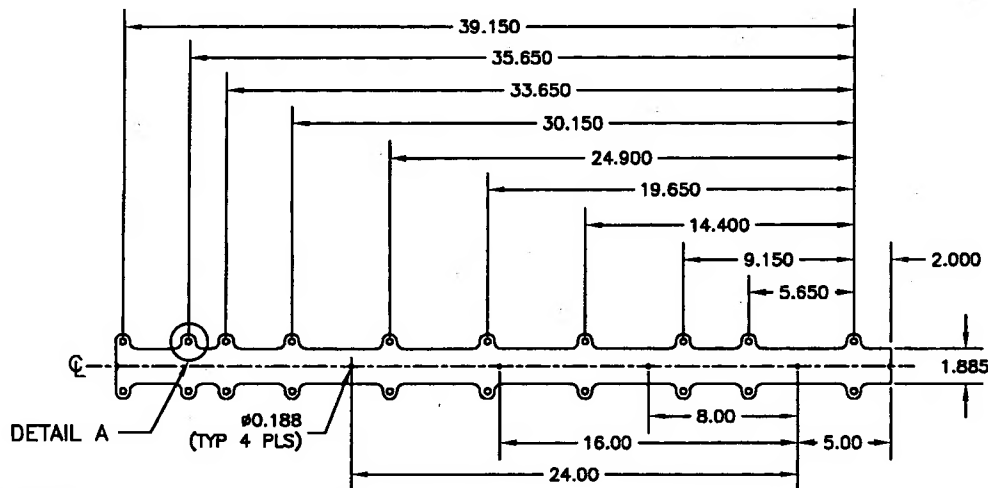
NOTE: Date & initial all entries

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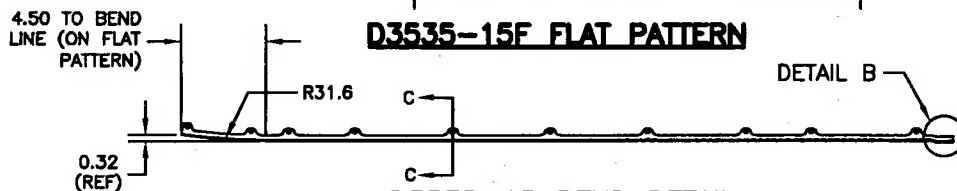
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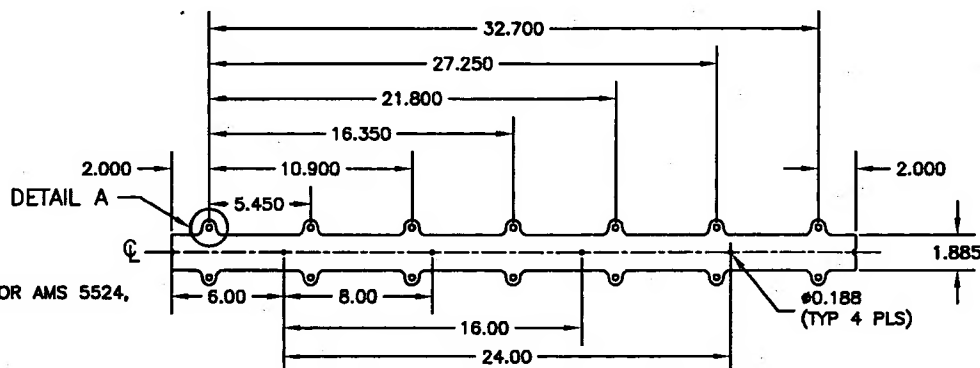
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		D3535	SHEET 2 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10



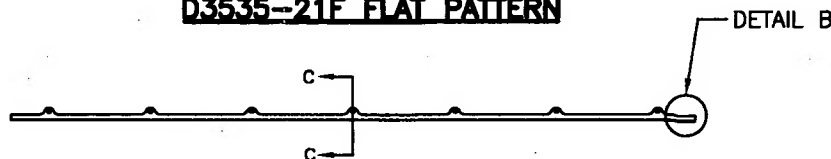
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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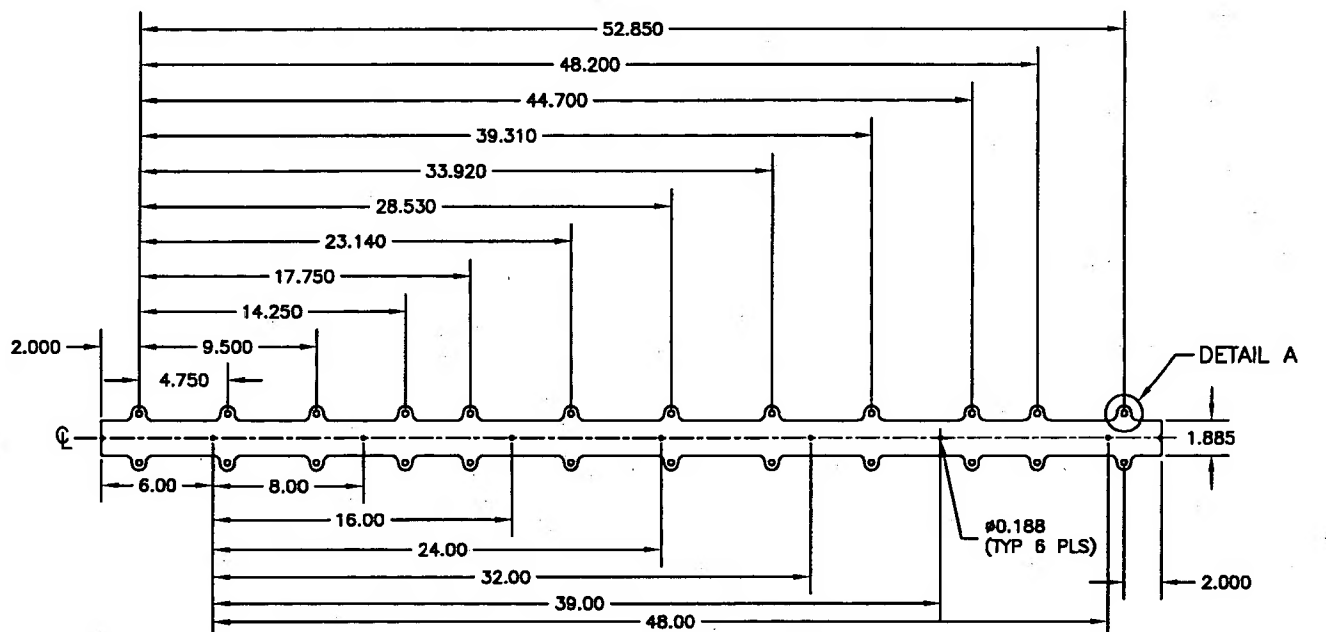
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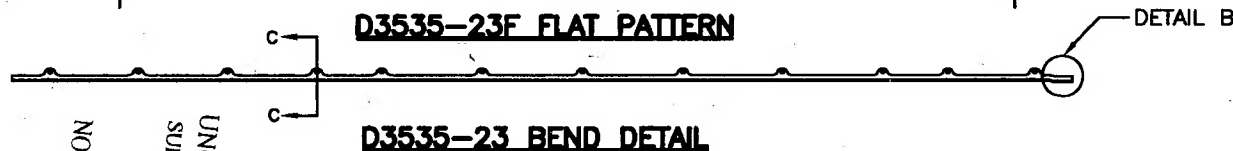
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07.04.24

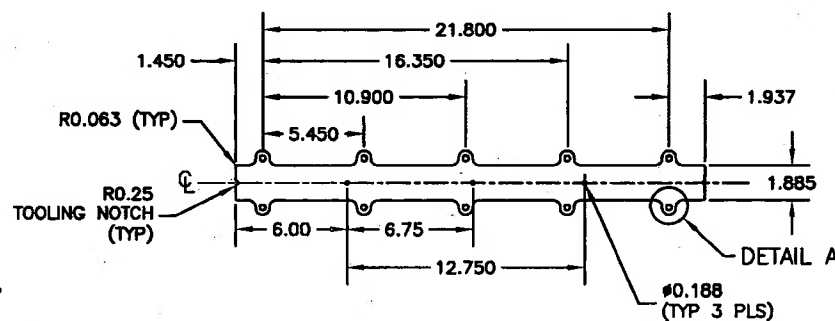
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 3 OF 7		
		REV. B		



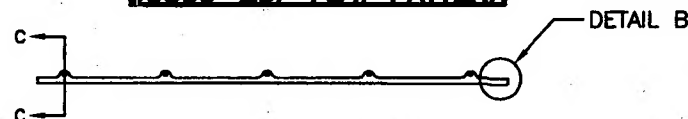
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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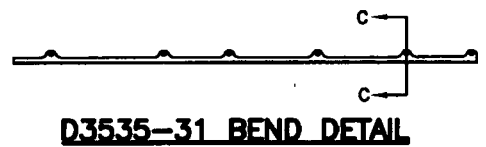
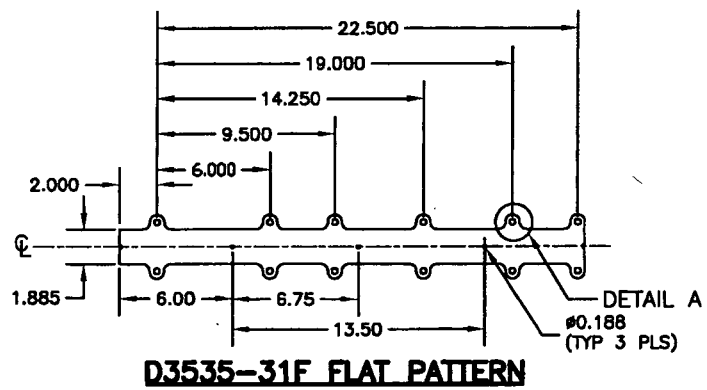
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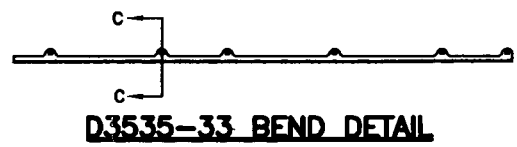
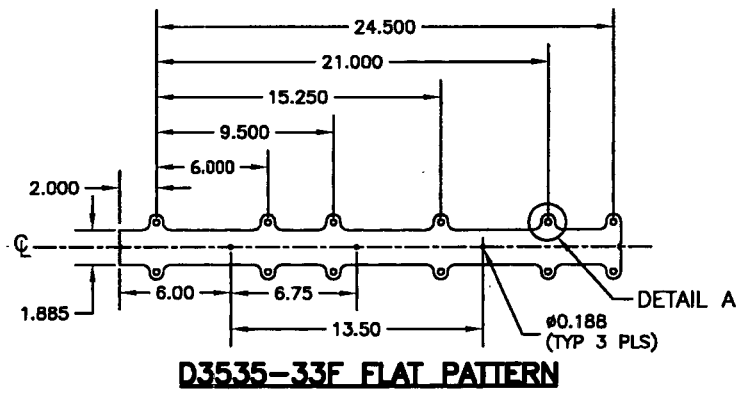
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07.04.24

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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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NOTES

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QA: N/C Closed: _____ Date: _____

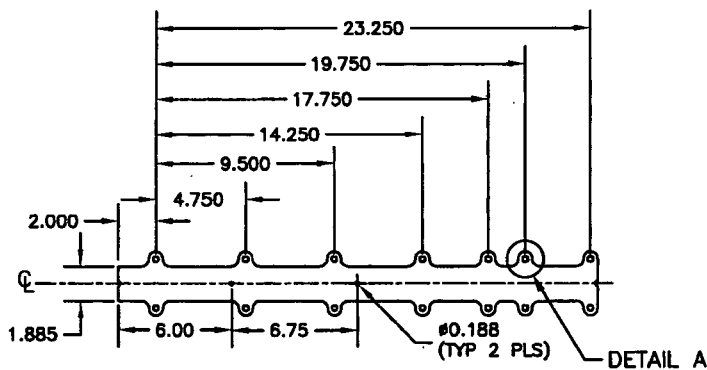
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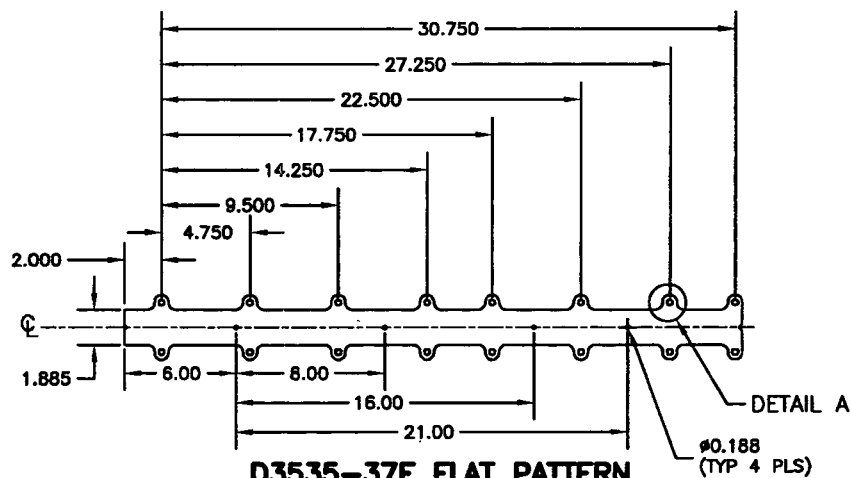
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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		D3535	SHEET 5 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

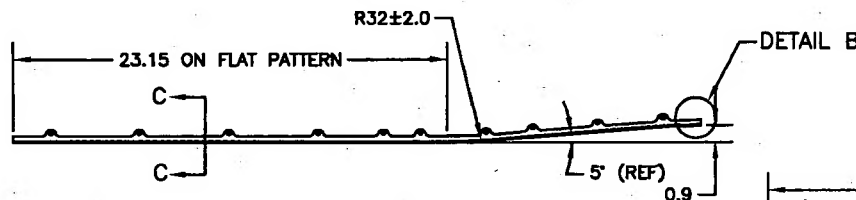
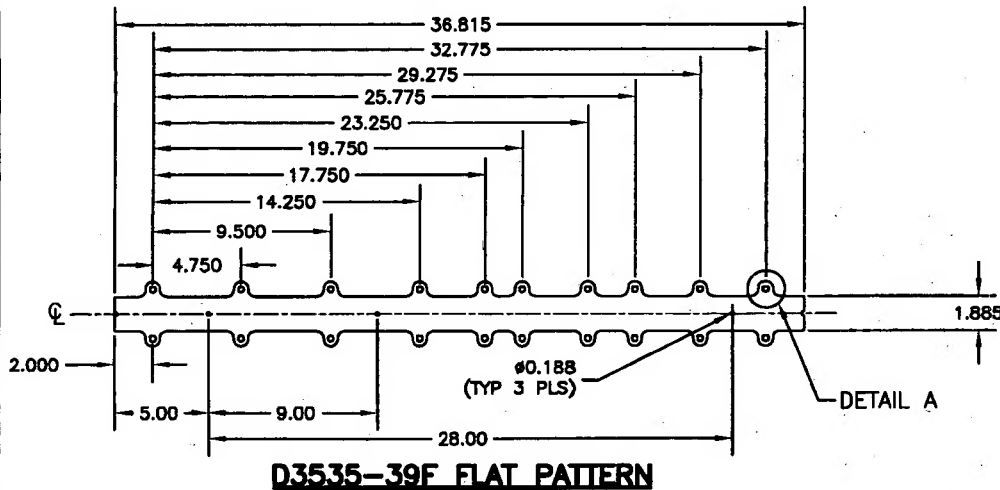
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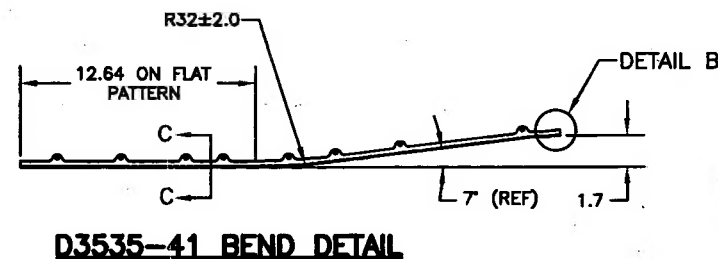
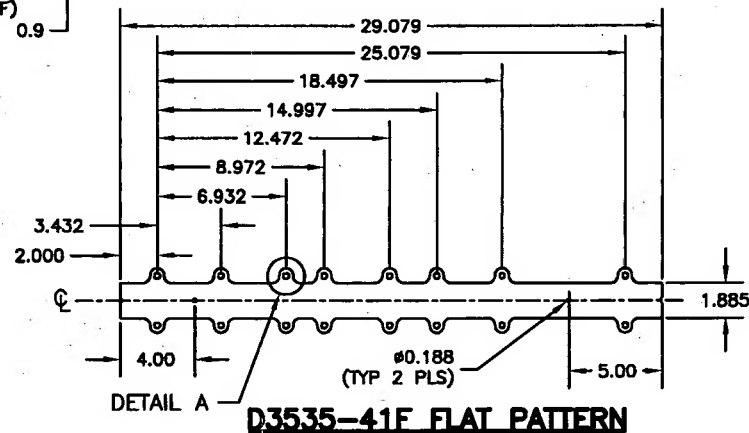
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**NOTES**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	AM	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE
		1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

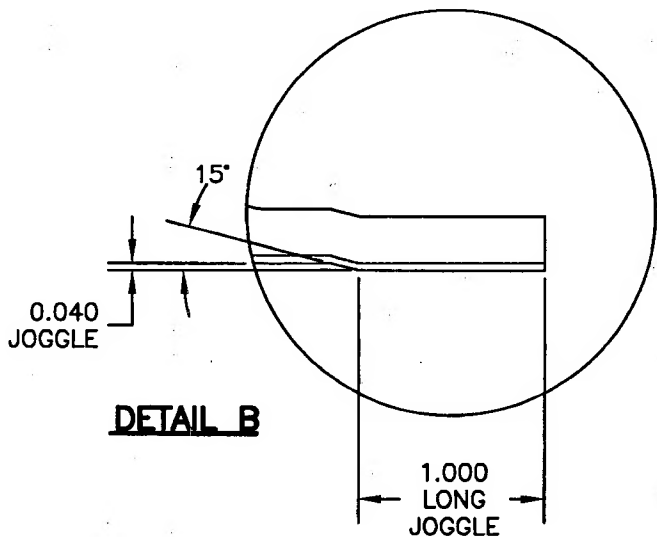
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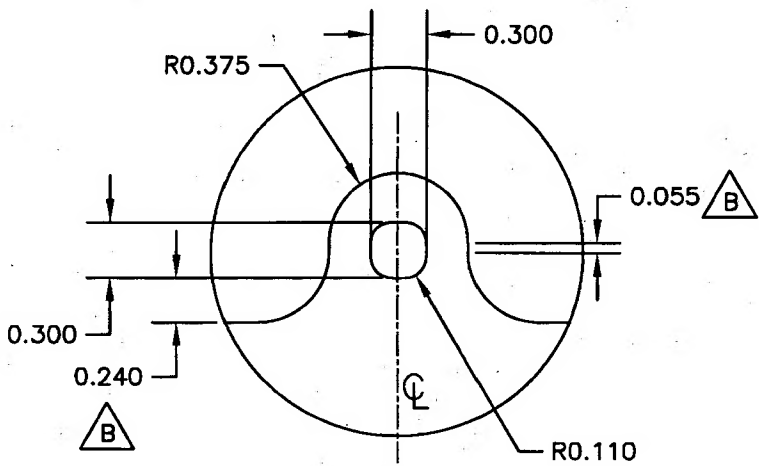


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17		TITLE WEARSHOE	SHEET 7 OF 7
		SCALE 1:1	

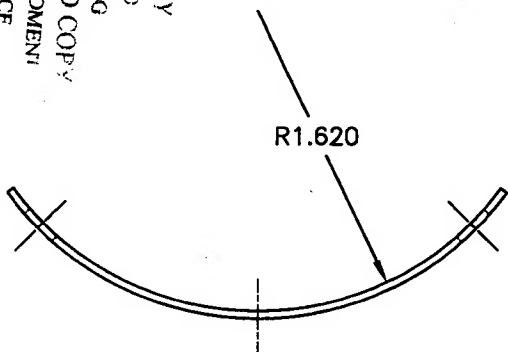
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
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